











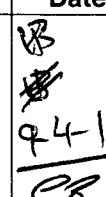

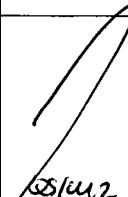
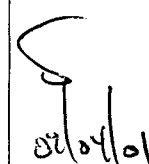
Date: Wednesday, 11/03/2009 12:58:57 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 46439	
Estimate Number : 11167	
P.O. Number :	Part Number : D32783
This Issue : 11/03/2009 S.O. No. :	Drawing Number : D3278 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 44780	Material :
Written By :	Due Date : 23/03/2009 Qty: 40 Um: Each
Checked & Approved By : <u>JUD 09.03.11</u>	
Comment : Est. A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	MDELRINS0125
	Black Delrin Sheet .125
	
	
Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.4448 sf(s) Black Delrin Material: Black Delrin/UHMW 0.125" thick (M-DELRIN-S0.125x30.0) Identify for D3278-3 Batch: <u>15607</u> <u>B 9-3-31</u>	
2.0	WATER JET
	FLOW WATER JET
	
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3278 Dwg Rev: <u>C</u> <u>B 9-3-31</u> Prog Rev: <u>C</u> 2-Deburr if necessary <u>09/04/01</u> <u>(67)</u>	
3.0	QC2
	INSPECT PARTS AS THEY COME OFF MACHINE
	
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-3-31</u> <u>(PB)</u>	
4.0	QC8
	SECOND CHECK
	
	
Comment: SECOND CHECK <u>09/04/01</u> <u>(67)</u> <u>(63)</u> <u>center</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46439</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/06	# 20	Part Part found with a sample in a box size the hole. R.C. looks like was touched by deburring tool. lack of attention.		Scrap and Destroy no replace Q ty	 94-1 EB	 09/04/06		 09/04/06

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:58:57 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 46439

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D3278

2-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St81

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46439
Description: Spacer		Part Number: D3278-3
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.986	✓			
1.98	+/-0.030	1.986	✓			
1.480	+/-0.005	1.481	✓			
0.250	+/-0.010	.251	✓			
1.480	+/-0.005	1.481	✓			
0.250	+/-0.010	.251	✓			
Ø0.098	+0.005/-0.000	.100	✓			
R0.13	+/-0.030	.13	✓			
0.125	+/-0.010	.125	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-3-31	Date: 09/03/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.02.02	Dwg updated per JLM	KJ/JLM	
D	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	JB

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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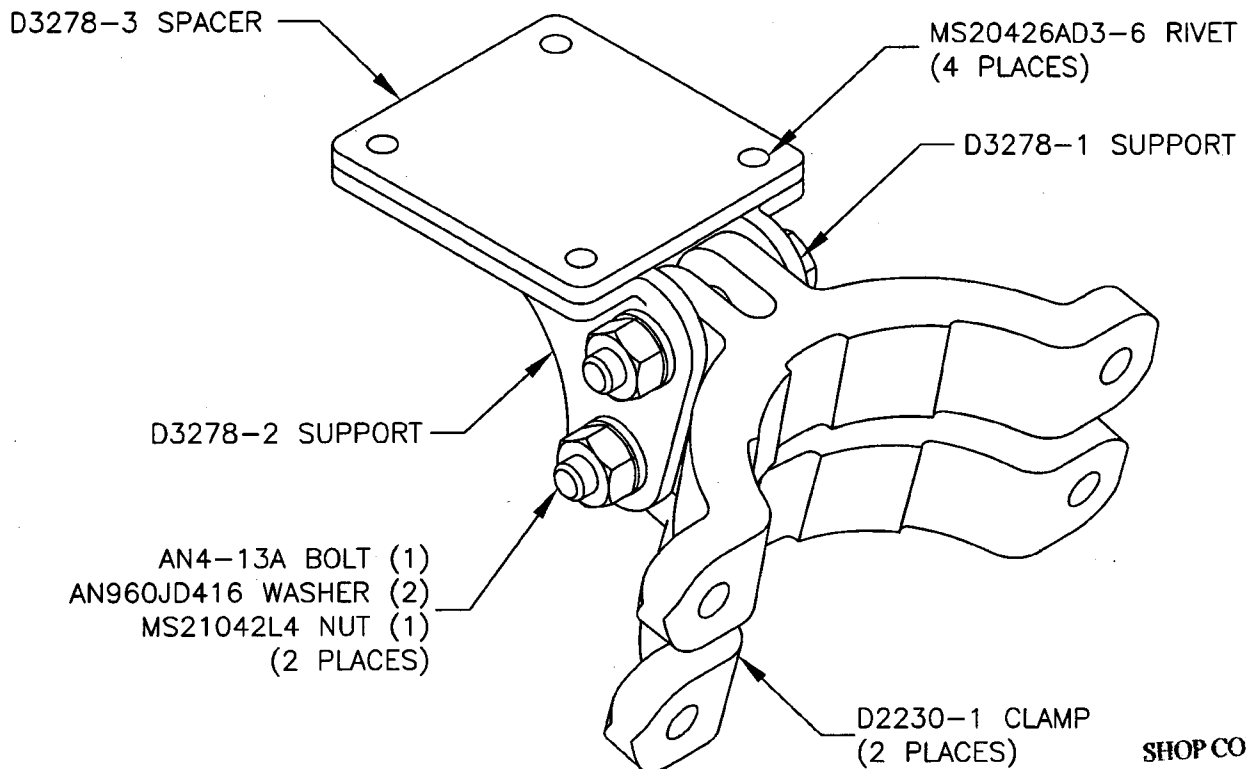
NOTE: Date & initial all entries



DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

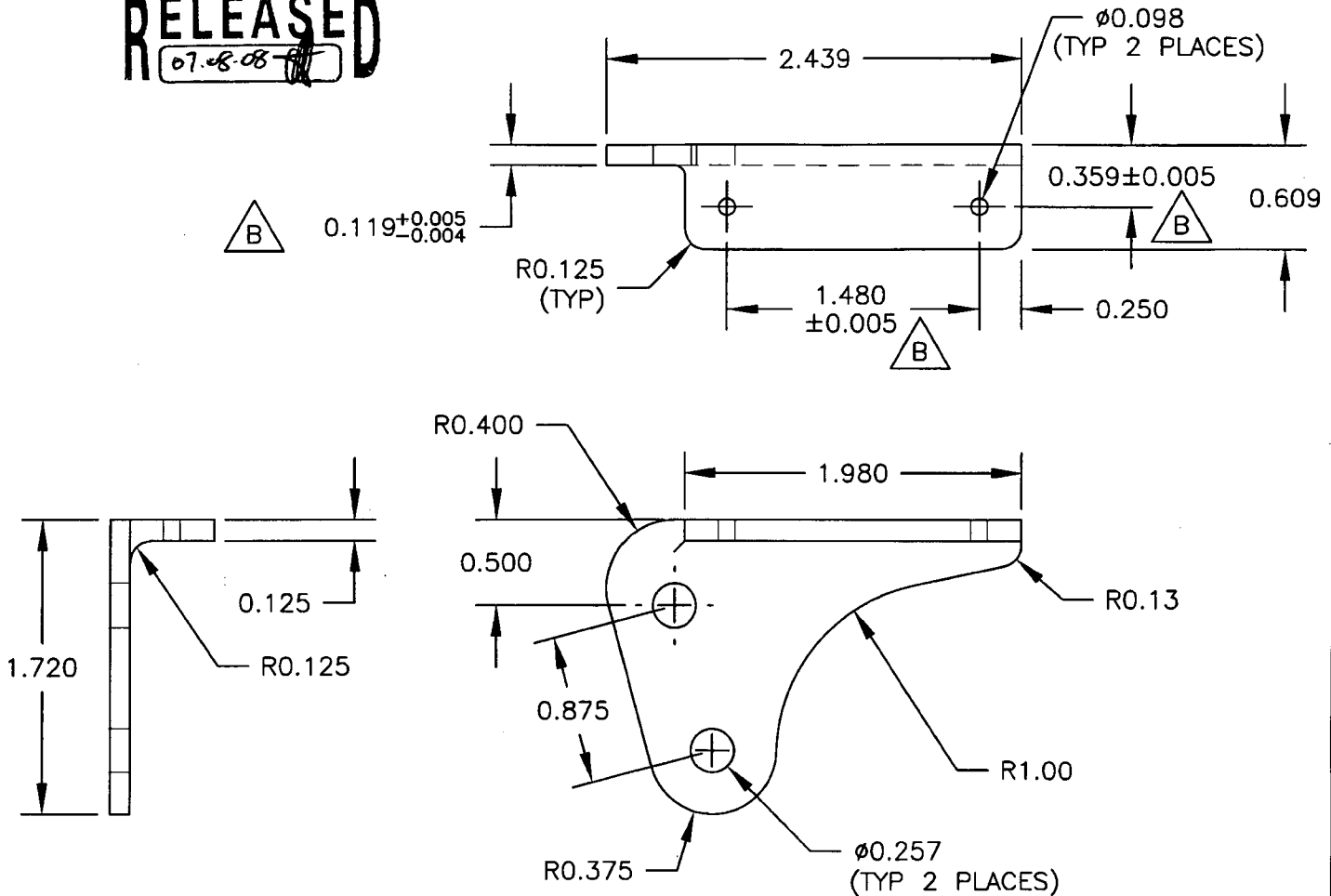
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

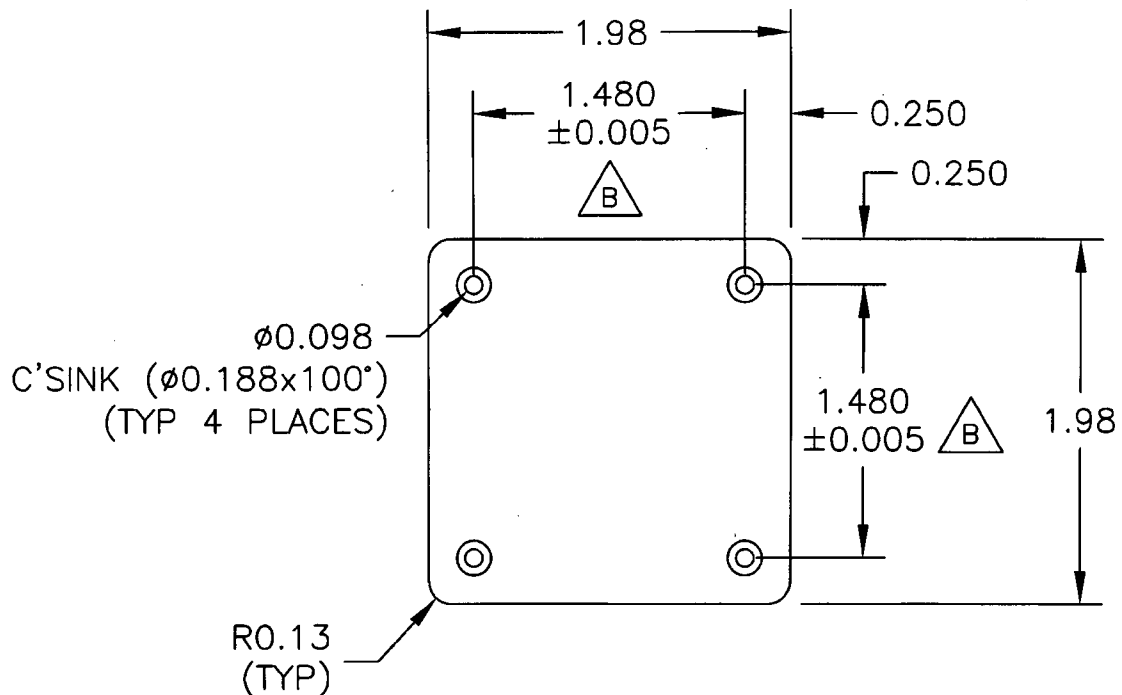
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NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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